



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3407-3
Job Sheet 177182



Part No: D3407-3

Job Qty: 20 ea

Part Name: Stem



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecm 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Machining-2		
100	Doosan	20 pcs	6/15/18	6/15/18	0.10	6.85	Doosan		
110	QC	20 pcs	6/15/18	6/15/18	0.00	0.00	QC2 Machining-2		
120	QC	20 pcs	6/15/18	6/15/18	0.00	0.00	QC8 Machining-2		
130	Packaging	20 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1		
140	QC21-SA	20 Ea	6/15/18	6/15/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FA597 Rev: ____ & Dwg D3407 Rev: ____
Descriptions: 130 - LOCATION: WA001

DAS
21
9-89

AUG 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	7.3200 ft (.366 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-R0.750	7	16	0

Part Specifications

Specifications could not be found.

Start At 10h15 to 12h = 1.75
12h30 to 2h30 = 2 - 3.25

Plex 5/8/18 10:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

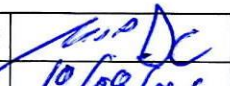
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	171182
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.070				
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.2645				
Major Ø	Max: 0.249 Min: 0.2425	.247				
Ø0.625	+/-0.010	.625				
Ø0.363	+/-0.010	.363				
Ø0.750	+/-0.010	.749				
R0.100	+/-0.010	R.1				
0.470	+/-0.010	.467				
0.250	+/-0.010	.249				
2.555	+/-0.010	2.545				
3.305	+0.000/-0.010	3.295				
4.325	+/-0.010	4.328				
0.150	+/-0.010	.156				
0.550	+/-0.010	.556				
0.625	+/-0.010	.627				
0.250	+0.010/-0.000	.258				

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	18/08/04	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	S	DART AEROSPACE Container No: S099297 Part: D3407-3 Job No: 177182 Serial No/Batch: S099297 Revision: G Inspector: _____ Exp Date: _____ Instructions: Various STC's DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Engineering ☐ Quality ☐ Other ☐ ARB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____ Description Work Order De
Date : _____	Step #:	

Root Cause	FAULT CATEGORY	
Environment ☐	Temperature/Cure ☐	Power Loss/Surge ☐
Design ☐	Set-up ☐	Folio/Program ☐
Doc/Data ☐	BOM/Route ☐	Grain ☐
Equip/Tooling ☐	Broken/Damage/Defect ☐	Weld ☐
Handling/Pre ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐
Material ☐	Contamination ☐	Out of Sequence ☐
Internal Transport ☐	Countersink ☐	Off-set ☐
Tribal Knowledge ☐	Cut Too Short ☐	Mislabeled ☐
LOA ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐
Substation ☐	Drill Holes ☐	Misaligned/off center ☐
Past Expiry Date ☐		
Misidentified ☐		

No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	OTHER : _____
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